

Wednesday, June 08, 2016 2:25:11 PM

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1 FF AUG 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : ☐																	

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OTHER :																																																																									

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147264

Page 3

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/30/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 6/8/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

Pick Kit

0.00

150

Packaging

Memo

0.00

Packaging

1 FF AUG 25 2016

160

0.00

160

Small Fab

Small Fab

Memo

0.22

Small Fab

1- install remaining parts as per dwg D412-769-1

1 FF

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

DAS
38
9-89

AUG 25 2016

DQA: _____ Date: _____

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
400 210 01				01 01 01					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
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Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
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Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

Work Order ID 147264

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147264

Page 4

Item ID: D412-769-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Facing Seat Assembly, LH

Start Date: 5/30/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/8/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Identify as per dwg & Stock Location: _____

0.00

180

Packaging

Memo

PPP147629

0.00

1X

DAS
28
9-89

AUG 24 2016

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.02

DAS
21
9-89

AUG 25 2016

Quality Control

mf
16-8-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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																								OTHER : ☐																																							

Picklist Print

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Page 1

Work Order ID: 147264

147264

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 5/30/2016

Required Date: 6/8/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 08.05-12 new issue DD verified by:EC
 IPP Rev:B 08-07-17 revB as per dwg DD verified by:ec
 IPP Rev:C 08-08-21 move D3792-1 after powder coat DD verified by:EC
 12.07.27 (DEO-B1) (ECN12-621) DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-5A		Purchased	No			110	Each	222.0000	6	6			
AN3-5A									**	<u>13058</u>			DAS 6 9-89
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FP001				4					
				m133686				2					
				m134055				2					
				ST350				218					
				m134502				218					
AN4-15A		Purchased	No			110	Each	158.0000	2	2			
AN4-15A									**	<u>134935</u>			DAS 6 9-89
Bolt													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				26					
				120449				26					
				ST343				132					
				m134762				132					
AN45-13A		Purchased	No			110	Each	30.0000	1	1			
AN45-13A									**				
EYE BOLT													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST339				30					
				m134570				10					
				m134587				20					

AUG 2 2016
DAS
6
9-89

DQA: _____ Date: _____



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Picklist Print

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Work Order ID: 147264

147264

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 5/30/2016

Required Date: 6/8/2016

Start Qty: 1.00

Required Qty: 1.00

AN5-10A Purchased No

110 Each

72.0000 6 6

AN5-10A

Bolt

135390

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

51

122800

51

ST338

21

m134634

21

AN5-13A Purchased No

110 Each

57.0000 2 2

AN5-13A

BOLT

Location

Loc Qty

Loc Code

CA

2

m129682

2

GA

6

122800

6

over003

20

m134754

20

ST338

29

m132803

9

m134497

20

AN525-10R24 Purchased No

110 Each

35.0000 9 9

AN525-10R24

Screw

135040

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

35

m131467

35

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐						Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐													
		OTHER : ☐																							

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Work Order ID: 147264

147264

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 5/30/2016

Required Date: 6/8/2016

Start Qty: 1.00

Required Qty: 1.00

D3766-1 Manufactured No

110 Each 2.0000 1 1

D3766-1

Front Rail, LH

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST254

2

142113

2

D3766-3 Manufactured No

110 Each 10.0000 1 1

D3766-3

Rear Rail

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST254

10

143700

10

D3767-1 Manufactured No

110 Each 8.0000 1 1

D3767-1

Upper Rail

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST254

8

143703

8

D3782-041 Manufactured No

110 Each 0.0000 1 1

D3782-041

Front, Outboard Leg Assembly

**

DAS
6
9-89

D3782-043

Manufactured No

110 Each 2.0000 1 1

D3782-043

Front, Outboard Leg Assembly, LH

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST252

2

142112

2

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER :			
Misidentified ☐	☐	Past Due	☐				

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Work Order ID: 147264

147264

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 5/30/2016

Required Date: 6/8/2016

Start Qty: 1.00

Required Qty: 1.00

D3782-045 Manufactured No

110 Each 4.0000 2 2

D3782-045

Back Leg Assembly

Location

Loc Qty

Loc Code

DAS

ST257

4

6

143704

4

9-89

D3783-041 Manufactured No

110 Each 2.0000 1 1

D3783-041

Lateral Brace Assembly

Location

Loc Qty

Loc Code

DAS

ST253

2

6

142116

2

9-89

D3783-043 Manufactured No

110 Each 2.0000 2 2

D3783-043

Longitudinal Brace Assembly

Location

Loc Qty

Loc Code

DAS

ST253

2

6

144550

2

9-89

D3783-045 Manufactured No

110 Each 0.0000 1 1

D3783-045

Angle Brace Assembly

Location

Loc Qty

Loc Code

DAS

ST253

1

6

145550

1

9-89

D3784-041 Manufactured No

110 Each 1.0000 1 1

D3784-041

Seat Support Assembly, Center

Location

Loc Qty

Loc Code

DAS

ST253

1

6

145621

1

9-89

D3784-043 Manufactured No

110 Each 0.0000 1 1

D3784-043

Seat Support Assembly, LH

Location

Loc Qty

Loc Code

DAS

ST253

1

6

147528

1

9-89

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order ID: 147264

147264

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 5/30/2016

Required Date: 6/8/2016

Start Qty: 1.00

Required Qty: 1.00

D3784-044	Manufactured	No	110	Each	0.0000	1	1		
D3784-044								**	146965
Seat Support Assembly, RH									DAS 6
MS21042L3	Purchased	No	110	Each	1,907.000	9	9		9-89

MS21042L3

Nut

Location Loc Qty Loc Code

FP001	56
m133790	56
GA	269
m133790	3
m134360	266
OVER007	600
m134754	600
ST303	982
m134039	12
m134634	170
m134943	800

MS21042L4	Purchased	No	110	Each	1,818.000	2	2		
-----------	-----------	----	-----	------	-----------	---	---	--	--

MS21042L4

Locknut

Location Loc Qty Loc Code

GA	181
m133769	181
OVER007	1000
m134861	1000
ST303	543
m134762	543
ST305	94
m130922	94

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Work Order ID: 147264

147264

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 5/30/2016

Required Date: 6/8/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

110

Each

1,571.000

23

23

NAS1149D0363.J

Washer

134955

DAS 6 9.89

Location

Loc Qty

Loc Code

GA

465

m134055

465

ST263

1106

m134606

106

m134676

1000

NAS1149D0463J

Purchased

No

110

Each

3,657.000

4

4

NAS1149D0463.J

WASHER

135054

135390

DAS 6 9.89

Location

Loc Qty

Loc Code

GA

86

M132035

21

M134508

65

ST260a

2000

M134852

1000

M134943

1000

ST263

1571

M134754

1571

NAS1149D0563J

Purchased

No

110

Each

957.0000

20

20

NAS1149D0563.J

Washer

135054

DAS 6 9.89

AUG 2

Location

Loc Qty

Loc Code

GA

231

m125807

2

m133769

229

ST263

627

m134497

627

ST269

99

m128257

99

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Picklist Print

Wednesday, June 08, 2016 2:25:15 PM

Page 7

Work Order ID: 147264

147264

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 5/30/2016

Required Date: 6/8/2016

Start Qty: 1.00

Required Qty: 1.00

AN525-10R22

Purchased

No

160

Each

25.0000

11

11

AN525-10R22

Screw

**

~~1275072~~ 1300462/11

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

25

M131467

25

AN525-10R28

Purchased

No

160

Each

49.0000

2

2

AN525-10R28

SCREW

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST329

49

m134360

49

D3774-1

Manufactured

No

160

Each

4.0000

1

1

D3774-1

Seat Bottom, LH/RH

**

DAS
6
9-89

Location

Loc Qty

Loc Code

ST250

4

143701

4

D3774-3

Manufactured

No

160

Each

1.0000

1

1

D3774-3

Seat Back, LH/RH

**

~~144769~~ 147254

DAS
6
9-89

Location

Loc Qty

Loc Code

ST250

1

129470

1

D3775-1

Manufactured

No

160

Each

1.0000

2

2

D3775-1

Guard

**

144769

DAS
6
9-89
Aug 22 2016

Location

Loc Qty

Loc Code

ST053

1

127643

1

Wednesday, June 08, 2016 2:25:15 PM

Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY																																																											
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Work Order ID: 147264

147264

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 5/30/2016

Required Date: 6/8/2016

Start Qty: 1.00

Required Qty: 1.00

D3792-1

Manufactured No

160

Each

6.0000

3

3

6

9-89

D3792-1

Eye Bolt

Location

Loc Qty

Loc Code

ST253

6

127630

6

D4679-1

Manufactured No

160

Each

16.0000

2

2

AUG 22 2016

BAG
9-89

D4679-1

Spacer

Location

Loc Qty

Loc Code

GA

16

127580

16

MS21042L3

Purchased No

160

Each

1,907.000

19

(19)

MS21042L3

Nut

Location

Loc Qty

Loc Code

FP001

56

m133790

56

GA

269

m133790

3

m134360

266

OVER007

600

m134754

600

ST303

982

m134039

12

m134634

170

m134943

800

2
(19)

~~135056~~

135135

DAS
6
9-89

AUG 22 2016

Wednesday, June 08, 2016 2:25:16 PM

Shop Packet Print

Page 8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Page 9

Work Order ID: 147264

147264

Parent Item: D412-769-043

D412-769-043

Parent Item Name: Aft Facing Seat Assembly, LH

Start Date: 5/30/2016

Required Date: 6/8/2016

Start Qty: 1.00

Required Qty: 1.00

MS21042L5

Purchased

No

160

Each

437.0000

12

12

MS21042L5

Nut

**

134955

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

95

m127813

95

OVER007

100

m134509

100

ST303

242

m134055

6

m134676

36

m134762

200

NAS1149D0332J

Purchased

No

160

Each

1,258.000

11

11

NAS1149D0332J

Washer

**

135040

DAS

6

9-89

Location

Loc Qty

Loc Code

CA

6

m129682

6

FP001

22

m134502

22

ST260a

1200

m134738

600

m134848

600

ST264

30

m134502

30

AUG 22 2016

DQA: _____ Date: _____

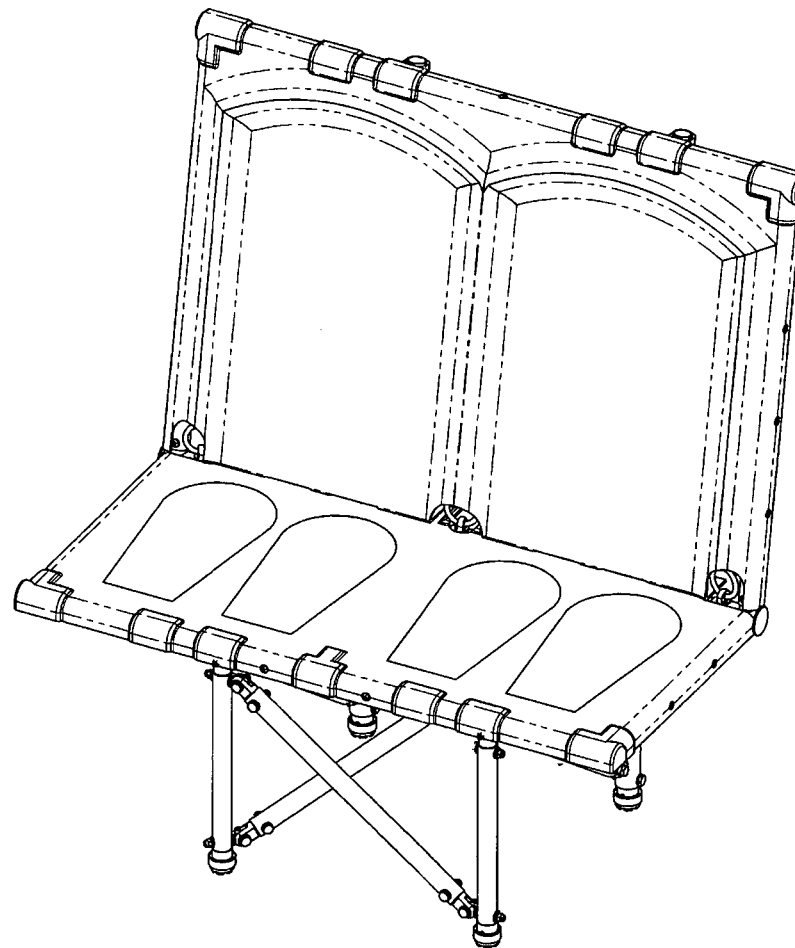


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Past Expiry Date ☐		Manufacturing Process ☐		OTHER : ☐																					
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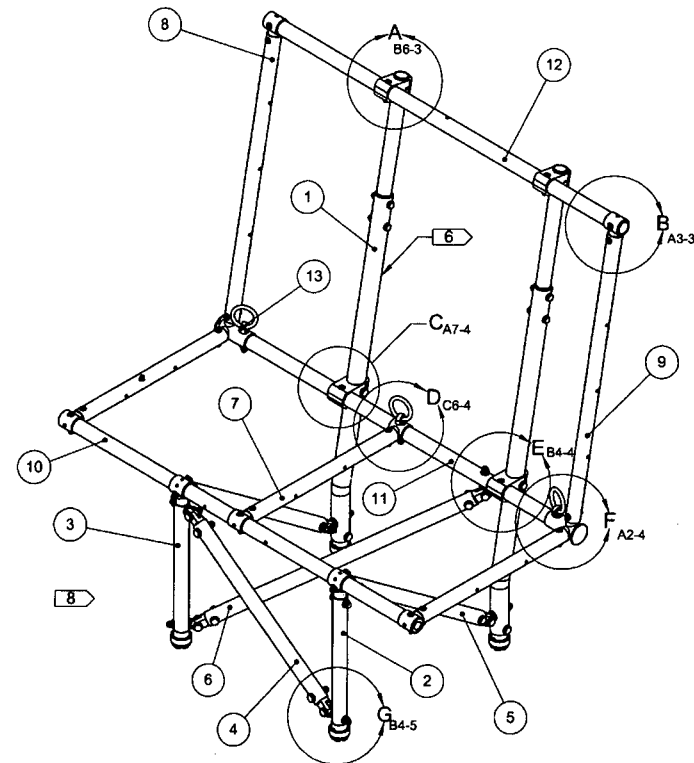
D412-769-043 AFT FACING SEAT ASSY, LH

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 147264 NLS
160609

RELEASED
08-07-09

B	NEW HARDWARE	HS	08.06.25
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D412-769-1	SHEET 1 OF 7
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	AFT FACING SEAT ASSY, LH	NTS
DATE	08.06.25	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3782-045	BACK LEG ASSY	2
2	D3782-041	FRONT INBOARD LEG ASSY	1
3	D3782-043	FRONT OUTBOARD LEG ASSY, LH	1
4	D3783-041	LATERAL BRACE ASSY	1
5	D3783-043	LONGITUDINAL BRACE ASSY	2
6	D3783-045	ANGLE BRACE ASSY	1
7	D3784-041	SEAT SUPPORT ASSY	1
8	D3784-043	SEAT SUPPORT ASSY, LH	1
9	D3784-044	SEAT SUPPORT ASSY, RH	1
10	D3766-1	FRONT RAIL, LH	1
11	D3766-3	REAR RAIL	1
12	D3767-1	UPPER RAIL	1
13	D3792-1	SEAT BELT EYE BOLT	3
14	D3775-1	GUARD	2
15	D3774-1	SEAT BOTTOM	1
16	D3774-3	SEAT BACK	1
17	AN3-5A	BOLT	6
18	AN4-15A	BOLT	2
19	AN45-13A	EYE BOLT	1
20	AN5-10A	BOLT	6
21	AN5-13A	BOLT	2
22	AN525-10R22	SCREW	13
23	AN525-10R24	SCREW	9
24	MS21042L3	NUT	28
25	MS21042L4	NUT	2
26	MS21042L5	NUT	12
27	NAS1149D0332J	WASHER (AN960JD10L)	13
28	NAS1149D0363J	WASHER (AN960JD10)	21
29	NAS1149D0463J	WASHER (AN960JD416)	4
30	NAS1149D0568J	WASHER (AN960JD516)	20



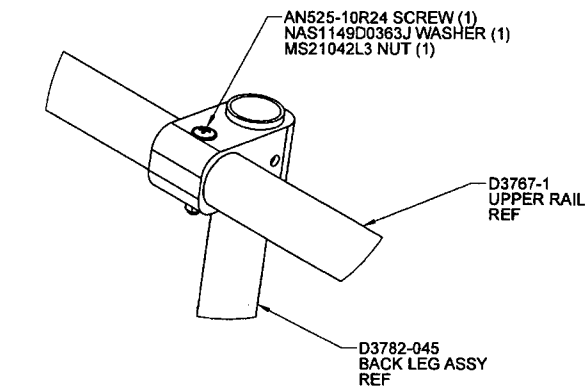
D412-769-043 AFT FACING SEAT ASSY, LH

RELEASED
08-07-09/10

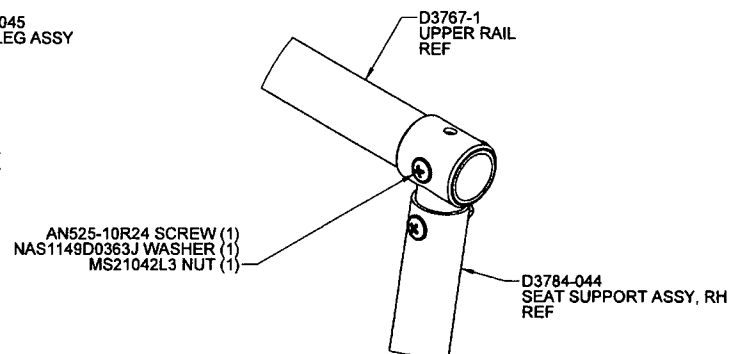
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLED SEAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3 PRIOR TO INSTALLATION OF SEAT BOTTOM/BACK (D3774-1/-3). MASK FRONT LEGS PRIOR TO POWDER COAT.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH D2729-1 RED DECAL ATTACHED TO BACK LEG ASSEMBLY (D3782-045)
- 7) WEIGHT: 30.0 lbs
- 8) ITEM 15 (D3774-1 SEAT BOTTOM) AND ITEM 16 (D3774-3 SEAT BACK) REMOVED FOR CLARITY

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-1	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, LH	NTS
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DETAIL A D2-2
UPPER RAIL TO BACK LEG ATTACHMENT
2 PL



DETAIL B C1-2
SEAT SUPPORT END ATTACHMENT
5 PL

RELEASED
07.09.10

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D412-769-1	REV. B
MFG. APPR.		TITLE AFT FACING SEAT ASSY, LH	SHEET 3 OF 7
APPROVED			SCALE
DE APPR.		NTS	
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8

7

6

5

4

3

2

1

D3792-1 SEAT BELT EYE BOLT (1)
NAS1149D0568J WASHER (1)
MS21042L5 NUT (1)

D3766-3
REAR RAIL
REF

D3784-041
SEAT SUPPORT ASSY, CENTER
REF

DETAIL D C2-2
SEAT SUPPORT ASSY, CENTER ATTACHMENT

AN45-13A EYE BOLT (1)
NAS1149D0568J WASHER (1)
MS21042L5 NUT (1)

AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

D3782-045
BACK LEG ASSEMBLY
REF

D3792-1 SEAT BELT EYE BOLT (1)
NAS1149D0568J WASHER (1)
MS21042L5 NUT (1)

DETAIL E C1-2
REAR RAIL TO BACK LEG ATTACHMENT

D3766-3
REAR RAIL
REF

AN525-10R24 SCREW (1)
NAS1149D0363J WASHER (1)
MS21042L3 NUT (1)

D3782-045
BACK LEG ASSEMBLY
REF

D3766-3
REAR RAIL
REF

DETAIL C C2-2
REAR RAIL TO BACK LEG ATTACHMENT

D3766-3
REAR RAIL
REF

D3775-1
GUARD

D3784-044
SEAT SUPPORT ASSY, RH
REF

DETAIL F B1-2
SEAT SUPPORT ATTACHMENT
2 PL

RELEASED
08-07-09/11/10

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D412-769-1	REV. B
MFG. APPR.		TITLE	SHEET 4 OF 7
APPROVED		AFT FACING SEAT ASSY, LH	
DE APPR.		SCALE	NTS
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8

7

6

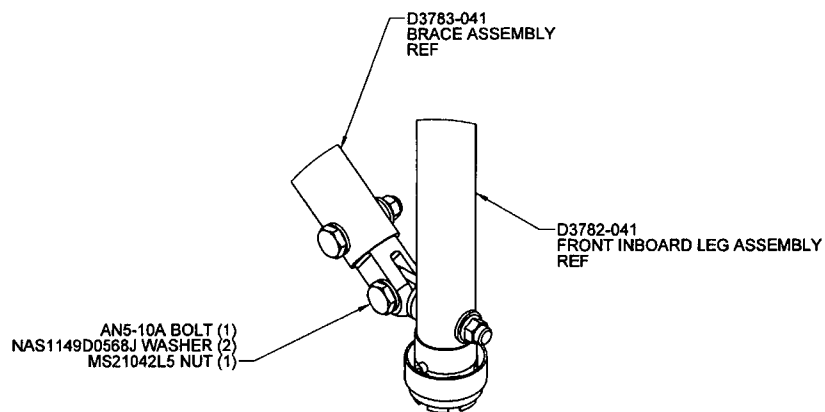
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4

3

2

1

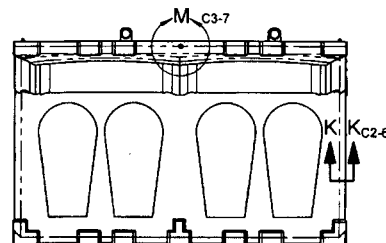


DETAIL G_{B2-2}
BRACE ATTACHMENT
 6 PL

RELEASED
 08-07-07/11/2

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D412-769-1	SHEET 5 OF 7
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	AFT FACING SEAT ASSY, LH	NTS
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8 7 6 5 4 3 2 1



AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
3 PL PER SIDE

D3784-044
SEAT SUPPORT, RH
REF

AN525-10R22 SCREW (1)
NAS1149D0332J WASHER (1)
MS21042L3 NUT (1)
2 PL PER SIDE

D3774-1
SEAT BOTTOM
REF

1

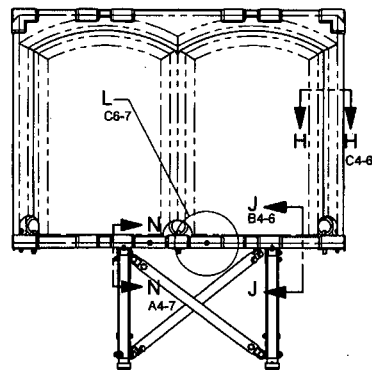
2

D3774-3
SEAT BACK
REF

D3784-044
SEAT SUPPORT, RH
REF

SECTION K-K
D7-6

SECTION H-H
B7-6



D3766-1
FRONT RAIL
REF

D3774-1
SEAT BOTTOM
REF

D3774-3
SEAT BACK
REF

D3766-3
REAR RAIL
REF

AN3-5A BOLT (1)
NAS1149D0363J WASHER (2)
MS21042L3 NUT (1)
6 PL

3

SECTION J-J
A7-6

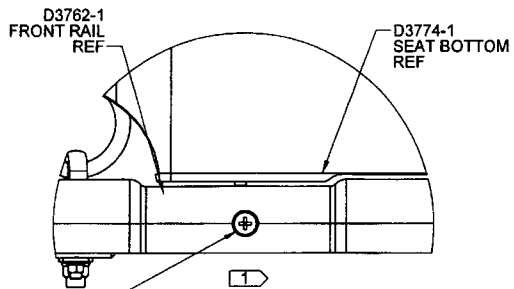
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08.06.25

NOTES:

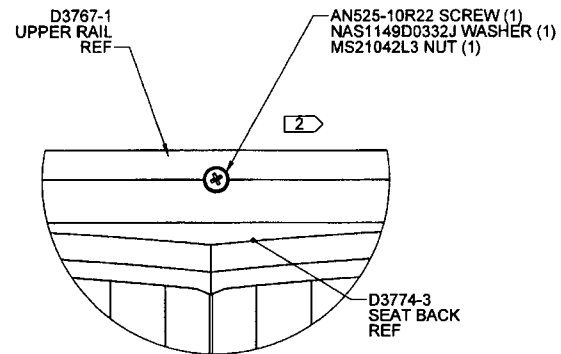
- 1) TRANSFER DRILL $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BACK (D3774-3) - 3 PL/SIDE
- 2) TRANSFER DRILL $\varnothing 0.201$ FROM SEAT SUPPORTS (D3784-043/-044) TO SEAT BOTTOM (D3774-1) - 2 PL/SIDE
- 3) TRANSFER DRILL $\varnothing 0.201$ FROM SEAT BOTTOM (D3774-1) TO SEAT BACK (D3774-3) - 6 PL

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED-		DRAWING NO.	REV. B
MFG. APPR.		D412-769-1	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, LH	NTS
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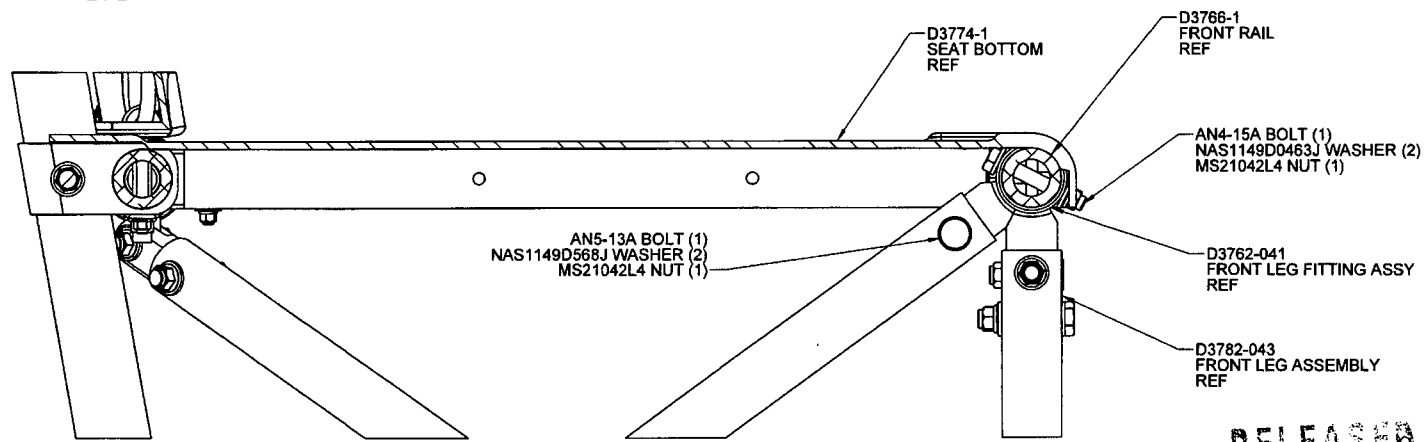
8 7 6 5 4 3 2 1



DETAIL L A7-6
SEAT BOTTOM ATTACH - FRONT DETAIL
2 PL



DETAIL M D7-6
SEAT BACK ATTACH - TOP DETAIL



SECTION N-N A8-6
FRONT LEG AND LONGITUDINAL ANGLE ATTACHMENT
2 PL

NOTES:

- 1) TRANSFER DRILL $\varnothing 0.201$ FROM FRONT RAIL (D3766-1) TO SEAT BOTTOM (D3774-1) - 2 PL
- 2) TRANSFER DRILL $\varnothing 0.201$ FROM UPPER RAIL (D3767-1) TO SEAT BACK (D3774-3) - 1 PL

RELEASED
08-07-02 11/00

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D412-769-1	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		AFT FACING SEAT ASSY, LH	NTS
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DRAWING NO. D412-769-1	TITLE AFT FACING SEAT ASSY, LH	REV. B	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D412-769-1-B-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED <i>UP</i>	MFG. APPR <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 12.07.09	DATE 12/7/10	DATE 12.07.10	DATE 12.07.10	DATE 12.07.10		

PURPOSE:

ADDITION OF QTY(2) D4679-1 SPACER PER PAR12-207.

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

PART NUMBER	DESCRIPTION	QTY. (-043)
D3782-045	BACK LEG ASSY	2
D3782-041	FRONT INBOARD LEG ASSY	1
D3782-043	FRONT OUTBOARD LEG ASSY, LH	1
D3783-041	LATERAL BRACE ASSY	1
D3783-043	LONGITUDINAL BRACE ASSY	2
D3783-045	ANGLE BRACE ASSY	1
D3784-041	SEAT SUPPORT ASSY	1
D3784-043	SEAT SUPPORT ASSY, LH	1
D3784-044	SEAT SUPPORT ASSY, RH	1
D3766-1	FRONT RAIL, LH	1
D3766-3	REAR RAIL	1
D3767-1	UPPER RAIL	1
D3792-1	SEAT BELT EYE BOLT	3
D3775-1	GUARD	2
D3774-1	SEAT BOTTOM	1
D3774-3	SEAT BACK	1
D4679-1	SPACER	2
AN3-5A	BOLT	6
AN4-15A	BOLT	2
AN45-13A	EYE BOLT	1
AN5-10A	BOLT	6
AN5-13A	BOLT	2
AN525-10R22	SCREW	11
AN525-10R24	SCREW	9
AN525-10R28	SCREW	2
MS21042L3	NUT	28
MS21042L4	NUT	2
MS21042L5	NUT	12
NAS1149D0332J	WASHER (AN960JD10L)	11
NAS1149D0363J	WASHER (AN960JD10)	23
NAS1149D0463J	WASHER (AN960JD416)	4
NAS1149D0568J	WASHER (AN960JD516)	20

NEW

QTY WAS 13

NEW

QTY WAS 13

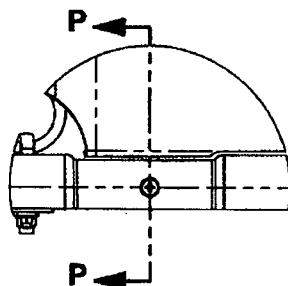
QTY WAS 21

RELEASED
2012-07-16
[Signature]

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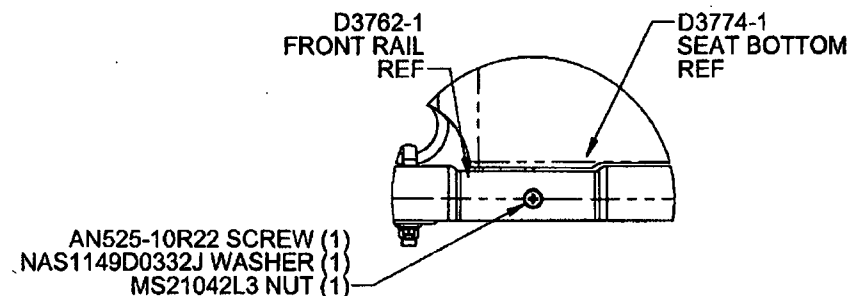
DRAWING NO. D412-769-1	TITLE AFT FACING SEAT ASSY, LH	REV. B	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D412-769-1-B-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN	CHECKED <i>UP</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 12.07.09	DATE 12/7/10	DATE 12-07-10	DATE 12.07.10	DATE 12.07.10		

IS:

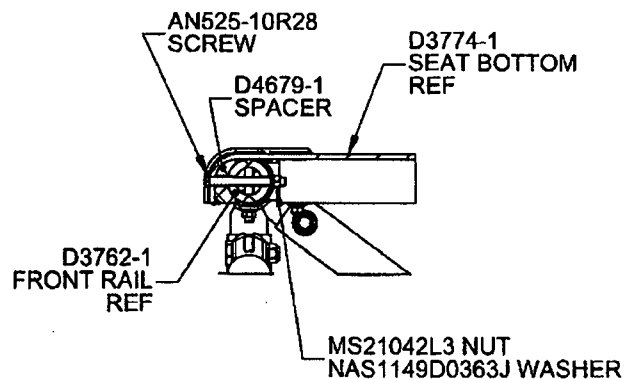


DETAIL L
SEAT BOTTOM ATTACH - FRONT DETAIL
2 PL

WAS:



DETAIL L
SEAT BOTTOM ATTACH - FRONT DETAIL
2 PL



SECTION P-P
INSTALLATION OF D4679-1 SPACER
2 PL

RELEASED
2012-07-16
[Signature]

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